	Monday, 7/9/2007 12:47:09 PM Kim Johnston	Dr	ocess Sheet			(3)	
	OLL DADOM Dort Delice		*	. TUDE			
Customer Job Number	: CU-DAR001 Dart Helico : 33415	pters Services	Drawing Name	: TUBE			•
Estimate Numb		ι.					
P.O. Number	: NA	2 0.9	Part Number	: D22823			
This Issue	: 7/9/2007 S.O. No.	: NA	<b>Drawing Number</b>	: D2282 REV E			
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: <b>////</b> Type	: MACHINED PARTS	Drawing Revision	: E		100	-
Previous Run	: 33259		Material Due Date	: 7/30/2007	Qty:	ر ∪m:	Each
Written By		mma		. 1700/2007	u.y.	Jov OIII.	Lucii
Checked & App Comment	: Est Rev:A	Removed from 9 Digit	 05-12-02 JLM				
	<del></del>	Nemoved nom a Digit	00-12-02 JEW				
Additional Prod	duct						
			rend of the second of the seco			·	
Job Number:							
Seq. #:	Machine Or Operation:		Description :				20
1.0	M304TR0675W091	304	RD Tube .675 x .091W				
Cor	mment: Qty.: 0.2078 f(s)/U	·	•				
			s, Ø0.675" OD, 0.091" wa	all thickness			
	(M304TR0.675W.091)						
	Batch <u>M 10533</u>		719				
2.0	HARDINGE	is.	RDINGE CNC LATHE SMALL	140000	1111 <b>11</b> 11 1 <b>11</b> 1		
Cor	mment: HARDINGE CNC LAT	HE CMALL	<u> </u>				
	MINOR HARDINGE CHC LAT	TIL OWALL	erak i				
	1-Turn as per Dwg D2	2282 and Folio FA188					
!			/ /				
	2-Deburr	120	07/09/19				i
3.0	QC2	INS	PECT PARTS AS THEY COME	OFF MACHINE		•	
Cor	mment: INSPECT PARTS AS	THEY COME OFF MACH	INE DIP OF	7/05/20			
4.0	QC8	SEC	COND CHECK	, ,			
				,		•	
				<u> </u>			
	mment: SECOND CHECK			11/07.09	20	(i	$\widetilde{\omega}$
5.0	PACKAGING 1	PAC	CKAGING RESOURCE #1	/			
Cor	mment: PACKAGING RESOU	RCE#1					
	Identify and Stock		1/1/				
	Location:	Ch 10	1/19/20	(100)			
		1/1/1					
		//					

## **Dart Aerospace Ltd**

W/O:		WORK ORDER	CHANGES				- <del></del>				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No		PAR #: Fault Category:	NCR: Yes/	No) po	A: 5	Date:	ે હમાન/2હે				

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annroval			
DATE ST	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
					·						

NOTE: Date & initial all entries

Date:

Monday, 7/9/2007 12:47:09 PM

User:

Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 33415

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U Aug. 20

## Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES		·			
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
						-			
					<i>P</i>		i.		
Part No	):	PAR #:	Fault Category:	NCR: Ye	s No DQ	A:	Date:		

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
		· ·	QA: N/C Closed:	Date:

NCR:			WORK ORDI	ER NON-CONFORMANCI	RMANCE (NCR)					
		Description of NC		Corrective Action Section B		Verification Approva				
DATE	STEP	Section A	Initial Action Description Sign & Section C Chief Eng Chief Eng Date			Chief Eng	Approval QC Inspector			
					,					
						*				
						٠	ć			
							:			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33415
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

	Х	First Art	icle	Proto	otype	
		A . 4 1				

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.375	+0.000/-0.020	2.365				
					,	
***						
						-
· <del>,</del>						
***						
<u> </u>						

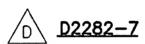
Measured by: RP,	Audited by:	Prototype Approval:	N/A
Date: 67/09/19	Date: 07/09/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	Tolerance changed	KJ/JLM	-1
С	06.03.15	Dwg Rev update	KJ/JLM O	

				•
	DESIG	и BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
1/P/4V777	CHECKED		APPROVED	DRAWING NO. REV. E
		W	1/20	D2282 SHEET 1 OF 2
	DATE			TITLE SCALE
	05.0	06.07		HANDLE TUBES 1:1
	Α		94.10.14	NEW ISSUE
DELKASEN	В		95.03.23	RE-DESIGN
h do b	С		97.10.20	CORRECTED NUMBERING SCHEME
05/09/16	D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
85/01/	E		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030

<u>D2282-3</u>

 $2.375_{-0.020}^{\phantom{-0.000}}$ 

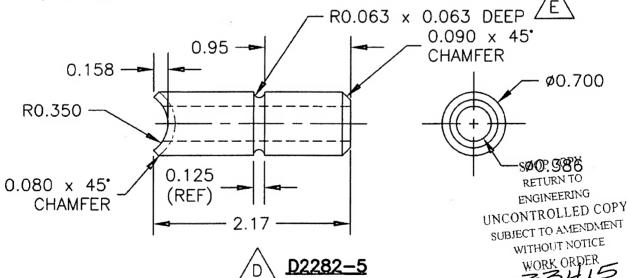


ø0.675 (REF)

Ø0.493 (REF)

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

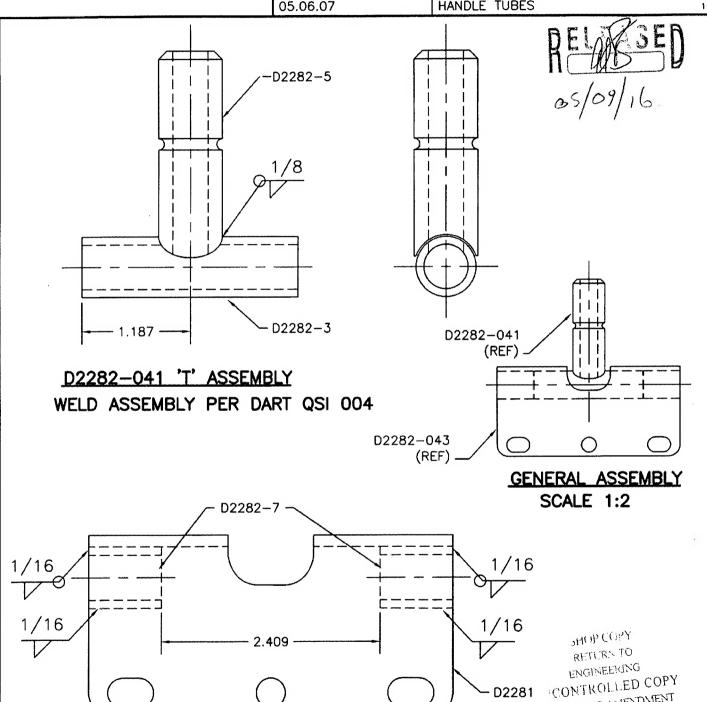
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
l u'	In	D2282	SHEET 2 OF 2
DATE	1 800)	TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

D2281

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